



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-021
Job Sheet 171805



MUST SHIP 22/02

- ship Alone -

Part No: D3391-021

Job Qty: 1 pcs

Part Name: Fwd Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/22/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV J SHEETS 4,5 IPP A 05.09.13 New issue KJ/JLM IPP B IPP C IPP D 07.03.13 rev F dwg EC IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD IPP Rev:f ECN 1056 07-11-12 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

5042046

DART
AEROSPACE
S042046

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com



Fwd Tube Assembly

PART NO: D3391-021

Original Serial #: S042046

Revision:

Operation:

Change No:

Start up Operation 02/13/18

Job No: 171805

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/21/18	0.00	0.00	Start Up Skid tubes-1		
100	Skid tubes	1 pcs		2/21/18	0.00	0.82	Skid tubes-4		M66
110	CNC Bend Skid tubes	1 pcs		2/21/18	0.00	1.00	CNC Bend Skid tube		M66
120	QC	1 pcs		2/21/18	0.00	0.00	QC5		BE
130	CNC Vertical Machining	1 pcs		2/21/18	2.21	1.00	HAAS1-3		32/18/02/17
140	QC	1 pcs		2/21/18	0.00	0.00	QC2 Machining-2		50.18/02/17
150	Mill Conv	1 pcs		2/21/18	0.00	0.27	Mill Conv 1		2.0.0.
160	QC	1 pcs		2/21/18	0.00	0.00	QC2 Machining-2		2.0.0. 18-02-19
170	QC	1 pcs		2/21/18	0.00	0.00	QC8 Machining-2		2.0.0. 18/02/21
180	Skid tubes	1 pcs		2/21/18	0.00	0.82	Skid tubes-4		M66 DAS
190	QC	1 pcs		2/21/18	0.00	0.00	QC5		38
200	HandFinish	1 pcs		2/21/18	0.00	0.33	HandFinish1		18-02-22
210	QC	1 pcs		2/21/18	0.00	0.00	QC7-2		
220	Skid tubes	1 pcs		2/21/18	0.00	0.82	Skid tubes-4		M66
230	QC	1 pcs		2/21/18	0.00	0.00	QC5		18-2-23
235	HandFinish	1 pcs		2/21/18	0.00	0.33	HandFinish2		FEB 24 2018
241	SprayPaint	1 pcs		2/21/18	0.00	0.99	Spray Paint		FEB 24 2018
242	Outsource	1 pcs		2/21/18			ATE003-VC		N/A
250	QC	1 pcs		2/21/18	0.00	0.00	QC14		18-2-26
254	HandFinish	1 pcs		2/22/18	0.00	0.33	HandFinish4		
256	QC	1 pcs		2/22/18	0.00	0.00	QC5		EB
260	Packaging	1 pcs		2/22/18	0.00	0.00	Packaging3-1		SmS
280	QC21-SA	1 Ea		2/22/18	0.00	0.00	QC21		
320	Packaging	1 pcs		2/22/18	0.00	0.00	Packaging2		N/A

Part Op 100 - Cut as per dwg.

Descriptions: 110 - Bend as per Dwg D3391 Using Bend Prog 3391021

130 - 1-Machine as per Folio FA590 Rev. ____ & Dwg D3391 Rev. ____

150 - Drill X1 Aft cap as per Dwg D3391 .1875" dia

180 - 1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step 2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A") 6-Deburr & Scribe Batch number inside aft end. 7-Transfer drill D3391-021 with D3391-023

220 - 1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: 137073 exp. date: 08/18 cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary

235 - AND REALODINE AS PER QSI 005

Prime 137670
Paint 138741

DAS
21
9-89

FEB 27 2018 5039

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6013-047 386064	Skid tube Material	1 Ea (1 ea)	90-Start up Operation	
D3670-4-200	Bushing	4 Ea (4 ea)	220-Skid tubes	
AELS-1032-225	Insert	10 Ea (10 ea)	254-HandFinish	
AN3C4A	Bolt	10 Ea (10 ea)	254-HandFinish	
D3401-041	Tow Cap Assembly	1 Ea (1 ea)	254-HandFinish	
D3672-1	Washer, Phenolic	4 Ea (4 ea)	254-HandFinish	
D4095-051	Wearpad Fwd	1 Ea (1 ea)	254-HandFinish	
NAS1149C0332R	Washer	10 Ea (10 ea)	254-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6013-047	1	53	0
220-Skid tubes	D3670-4-200 5021404 ③	4	58	0
254-HandFinish	AELS-1032-225 F165393 ①	10	0	0
	AN3C4A 5019394	10	1,922	0
	D3401-041 F159546	1	2	0
	D3672-1 F150074	4	1,095	0
	D4095-051 M159402-120	1	28	0
	NAS1149C0332R 5019380	10	2,511	0

Part Specifications
Specifications could not be found.

Plex 2/8/18 1:04 PM dart.lacelle.linda

